

MANUFACTURING CENTER

CIGARETTE LIGHTS (5MM REGULAR FTB + TIOJ TAR/NICOTINE
SPECIFICATION (JPN)

EFFECTIVE DATE: 11/09/90

JAPAN

CIGARETTE LENGTH	: 63.0	TIOJ TAR	: 8.0 MG/CIGT	7.5 - 8.0
TOBACCO ROD CIRCUM.	: 24.80	NM		
TOBACCO ROD LENGTH	: 56.0	TIOJ		
FILTER LENGTH	: 27.0	NM	NICOTINE	.70 MG/CIGT .56 - .58
TIPPING LENGTH	: 32.000	NM		
TOTAL R.T.D.	: 4.70	(N, H2O)		
DILUTION TARGET	: 35.0 +/- 5.0 %			

TIPPING PAPER : 66MM X 3500M WHT DCL PPT EC 136 12-035-B LASER PERFORATED

GLUE ROLLERY : REFER TO ENGINEERINGS GLUE ROLLER VARIABLE PARTS CATALOG

TIPPING INFORMATION : BY TYPE-TIPPER AND CIGARETTE BRAND-CODE-SPECIFICATION

: BETWEEN ROWS/BAND WIDTH/TPR. CUT LENGTH/DRY PATCH SIZE
38.00 1.50 27.00 8.5 X 20MM

TIPPING ADHESIVE	: NATIONAL 32-1979	PVA	61-216-A
	: NATIONAL 32-2013 (FORMERLY 72-2782)	PVA	62-069-A
	: FULLER WB-3924-EL	PVA	61-458-A

SEAM ADHESIVE	: FULLER WB-3902U	PVA	61-444-A
	: NATIONAL 25-1068	PVA	61-210-A

STD. FILLER - PACK O.V.: A1330 - 12.00% LARK SUPER LIGHTS FTB

CIGARETTE PAPER : 27.25MM X 6500M 35CU/0.6% (R/D137/E878) 10-135-A

INK : "INK FOR PRINT DIE AND EXPORT OVERPRINTS"
: MARLBORO BLACK #37077(MK 9/MK 10/PROTOS) 60-915-A

PRINT DIE : MACHINE NUMBER

COMMENTS : COUNTRY REQUIRES QA SMOKING BY TIOJ METHOD. PACK
: PRINT TAR/NICOTINE IS 8.0/.7 MG/CIGT.(TAR RANGE
: ESTABLISHED BY FTC STANDARDS/NICOTINE RANGE 20%
: VARIANCE PER JAPANESE REQUIREMENTS.)

REASON FOR CHANGE : DILUTION TARGET CHANGED FROM 30.0% TO 35.0%
: (+/-5.0%) TO REFLECT CURRENT PRODUCTION AVERAGE
: WITH CURRENT TIPPING PRESSURE DROP, NO OTHER
: CHANGES IMPLEMENTED.

PREPARED BY : E. G. T. WEALEY
PREPARATION DATE : 10/30/90

PRINTING DATE : 10/30/90
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APPROVED BY: Charles M. Batis

SUPERCEDES SPECIFICATION DATED: 6/11/90

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